

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015210**Date Inspected:** 13-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr.Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

LAY DOWN YARD.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 005952.

Magnetic Particle Testing (MT)

This QA Inspector performed MT of 15% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated MT report for this date. The members are identified as OBG

Segment:11AW-Panel Point #95 and 96 weld Components. Total number of welds MT Tested: 87 No's. The weld designations are review as follows:

1. SEG065B-008,010,015~020,033~036,044,045.
2. SSD13A-PP95-039,041,043,045,047,049,051,053,097~104,106~114.
3. SSD29-PP95.5-087~094,099~106.
4. SSD13A-PP96-038~053,097~104,106~114.

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This QA Inspector Randomly observed the following work in progress:

Segment: 11BW.

Shielded Metal Arc Welding (SMAW) of weld joint OBW17D-022. Welder is identified as 067752. ZPMC Quality Control (QC) is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2114-FCM-1.

Refer attached photo for reference.

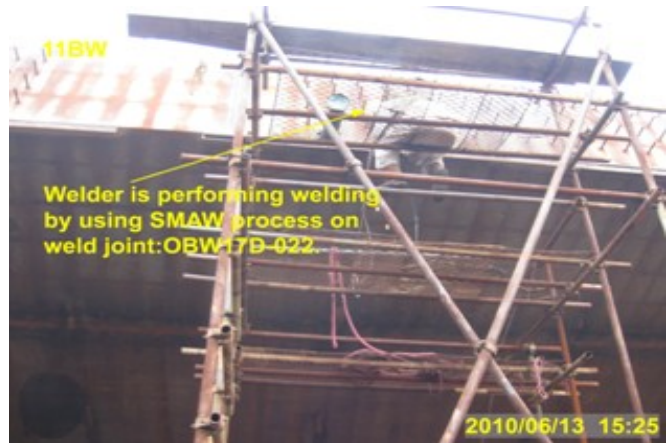
SMAW of weld joint OBW17D-066. Welder is identified as 067589. ZPMC Quality Control (QC) is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2114-FCM-1.

Refer attached photo for reference.

OLD BLASTING SHOP.

This QA Inspector received a ZPMC submitted notification number identified as 00378 for final tension verification on Tower lift: 1-47.6 M Cross bracing in old blasting shop. This QA Inspector arrived to site with notification and found that the work was not completed. ZPMC personnel was installing the bolts. Finally ZPMC QA Inspector cancelled the notification.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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Inspected By: Prabhu,Surendra

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer